

Date: Monday, 27/10/2008 3:19:25 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE BILLET
Job Number :	42991		
Estimate Number :	10035		
P.O. Number :		Part Number :	D6101007
This Issue :	27/10/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D6101 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :	41960	Drawing Revision :	A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	11/11/2008
Written By :		Qty:	50
Checked & Approved By :		Um:	Each
Comment :	Est. A: 01.05.04 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 7468C208110128

a) Description: Alluminum billet

b) 7.750" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

(50)

d) Grain direction along 7.750" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0

D6101007P

7075-T7351 8.25X7.75X2.5

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

7075-T7351 8.25X7.75X2.5

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

Pc 8/4/19 (50)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

9.14 08/11/23

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 27/10/2008 3:19:25 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 42991

Part Number: D6101007

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/11/20 (partiel)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/24 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

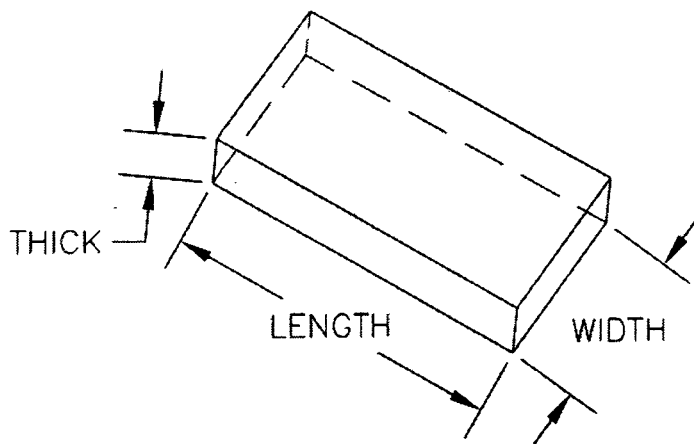
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *A*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

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010:4299/
080810127

31 373418 687772 01		Métaux Castle®		A.M. CASTLE & Co. (Canada) SHIPPED NOV 19 2008		573418	
D. REQUISITION CLIENT-CUSTOMER REQUISITION NO.		NO. COM. CLIENT-CUST. ORD. NO. 7468		COMPTÉ-ACCT. VEND.-SLS TERR. EXPÉDIE PAR-SHIP VIA 91037 200 50 MANITOULIN CP Carriage			
CHETEUR-PURCHASING AGENT LINDA LACELLE		TELEPHONE 413 632-3336		H/C TAXE NO. COM ORD 9 0 1 C/C		REGION LIVRAISON-DEL ZONE F.A.B.-F.O.B. PREPAID	
VRE A-SHIP TO:		VENDU A-SOLD TO: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY ON K6A 1K7		INFORMATION CRÉDIT-CREDIT INFORMATION		ROUTE 01*NL-11/0 30-NL-11/0 31-NL-11/1	
INSTRUCTIONS LIVRAISON-DELIVERY INQ-183568		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)		INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)			
DESCRIPTION - ITEM 1 2.5000 PLATE 7075-T7351 ALUM 8.25" X 7.75" BLACK W/RED STRIPE				QTE/UNITE COM.-ORDERED 50 PCS PCS		POIDS COM.-WT. ORDERED 808	
CERTIFICATE OF CONFORMANCE A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon. A.M. Castle & Co. (Canada) Inc. WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.				BALLOTS-BUNDLES 1 50		POIDS EXP.-WT. SHIPPED 808	
				FORME-SHAPE 36.3605QF		I.A.C. 6879	
INSTRUCTIONS TOL: +.030 / -.000 GRAIN TO RUN ALONG 7.75" THICKNESS TOL.: +.030 / -.000 PRIOR DIST/ORD: 01 687772				COULÉE INFO-HEAT INFO QTE-QTY 449115AS		ENT-WI	
INSTRUCTIONS (CONT'D.) 50x 8.25" x 7.75"							
DESCRIPTION - ITEM 2				QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
TERMS AND CONDITIONS OF SALE SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE				BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
				FORME-SHAPE 1 Box		I.A.C.	
INSTRUCTIONS				COULÉE INFO-HEAT INFO QTE-QTY		ENT-WI	
INSTRUCTIONS (CONT'D.)							
DESCRIPTION - ITEM 3				QTE/UNITE COM.-ORDERED		POIDS COM.-WT. ORDERED	
ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.				BALLOTS-BUNDLES		POIDS EXP.-WT. SHIPPED	
				FORME-SHAPE		I.A.C.	
INSTRUCTIONS				COULÉE INFO-HEAT INFO QTE-QTY		ENT-WI	
INSTRUCTIONS (CONT'D.)							
NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)				RECU PAR-RECEIVED BY		DATE RECU-DATE RECEIVED	

SHIP TO: A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
SOLD TO: AM CASTLE & CO- SOLD TO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
 Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4143976

CUSTOMER PO NUMBER: 01-14052	WORK PACKAGE:	CUSTOMER PART NUMBER: 8879 A97075-60	SHIP RUN/LOAD ID: 101388/8	GOV'T CONTRACT NUMBER:
KAISER ORDER NO: 1073780	LINE ITEM: 1	SHIP DATE: 9-OCT-2008	ALLOY: 7075	CLAD: BARE
TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 3624 LB	QUANTITY: 2 PCS EST.	S/L NUMBER: 2019785	GAUGE: 25000-IN	WIDTH: 48.500 IN
			LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevG
 ASTM B 209/Rev07
 B88 7055/RevA
 DPS 4.713/RevAH
 GSS16100/RevG

AMS-QQ-A-250/12
 ASTM B 594/Rev08
 CMMP 025/RevR
 EAC M81011/RevE
 MMS 159/RevN

AMS-STD-2154
 BAC 5438/RevH
 CSTI 006/RevC
 GAMPS 9101/RevB
 PS 21211/RevK

Test Code: 4297

Test Results

Lot: 449115A5 Cast 180

Drop 37

Ingot 3

(ASTM E8/B567)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	69.8 : 70.3 (480 : 485)	58.1 : 59.2 (401 : 408)	10.8 : 10.8

(ASTM E1004)

Conductivity %IACS :	41.4 Min	41.4 Max
(MS/M) :	24.0 Min	24.0 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.10	0.20	1.6	0.04	2.5	0.21	5.8	0.02	0.01	0.01	TOT 0.05

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.08	0.05	TOT	0.15

Aluminum Remainder

**KAISER
ALUMINUM**


Trentwood Works - Spokane, WA 99215
Phone: (800) 347-2586

CERTIFIED TEST REPORT

Serial Number
4143976

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CASTLE METALS CORP.
DATE RCVD 10/14/08
IAC 0819
APPROVED BY 

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

